

CLAIMS

We Claim:

1. A method of double color-molding a key top, comprising the steps of:

performing a first shot for injection-molding with light-shielding resin an outer

5 part that forms an outer line of a closed loop in a letter, figure, mark, or the like, and an inner portion that forms an inner line of said closed loop;

performing a gate-cut of an injection gate for light-shielding resin in both said outer portion and said inner part; and

performing a second shot for injection-molding a light-permeable resin layer
10 that contacts a front surface of each of said outer part and said inner part in such a manner that said light-permeable resin layer covers a gate trace on both said outer part and said inner part, which remains after said gate-cut.

2. A method of double color-molding a key top comprises the steps of:

15 closing an upper metal mold for a first shot including a plurality of gate holes, which are arranged so that they are connected to a cavity, for injecting light-shielding resin into an outer part that forms an outer line of a closed loop in a letter, figure, mark, or the like, and into an inner part that forms an inner line of said closed loop, and a lower metal mold having a core, which includes a convex portion that corresponds to a
20 planer shape of said closed loop;

performing a first shot for injecting light-shielding resin through said plurality of gate holes into a space remaining between said cavity of said upper metal mold and said core of said lower metal mold to injection-mold said inner part and said outer part;

opening said upper metal mold for a first shot and said lower metal mold;

25 performing a gate cut of an injection gate for light-shielding resin in both said outer part and said inner part;

changing said upper metal mold for a first shot to an upper metal mold for a second shot;

closing said upper metal mold for a second shot and said lower metal mold;
and

5 performing a second shot for injecting light-permeable resin into a space remaining between a cavity of said upper metal mold for a second shot and said lower metal mold to injection-mold a light-permeable resin layer in such a manner that it covers a gate trace in both of said inner part and said outer part, which remains after said gate-cut.

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3. A method of double color-molding a key top according to claim 2, wherein a height of said convex portion formed on said core of said upper metal mold for a first shot is approximately half of a thickness of said inner part or said outer part.

15 4. A method of double color-molding a key top according to any one of claims 1 through 3, wherein said light-permeable resin layer is a light-permeable chromatic resin layer that selectively allows a wavelength of a back light through.